Work Order March-12-13 1:45		<b>'7</b>		*982	77*							Page 1
Revision ID:	4003-13 wd Fuel Gutter	Line		Accept	*N900	<u>040</u>	100	)*	Setup	Start Stop	*N *N	S1* S2*
Start Date: 3/ Required Date: 3/ Reference:		Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item 1 Customer:							
		ML5	Date: 13-03-15	Tooling: SPC (Y/N):		ate:			Run .	Start Stop		R1* R2*
Sequence ID/ Work Center ID		Peration Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision	on Nbr										
D4003	A	: a										
*1 \\ \Chi \\ \X\ \\ \X\ \\ \X\ \\ \X\ \\ \X\ \\ \		<b>Memo</b> 1- Cut tube :	as per dwg	0.00				4	/	Ø		13-05-2
*110 *110* QC	Q	QC5- Inspect part compl Memo		0.00 SW 0.00 BS3	<i>\</i>			4				
Quality Control												
170 <b>*17</b> Packaging	lo	dentify as per dwg & Sto  Memo	ock Location:57083	0.00		6	L	<u>4</u> x		M. H	). 13	-05-30

Packaging

NCR: Yes / No						<b>WORK ORDER NON-C</b>	CON	<b>FORN</b>	VANCE / UPDATE					
										(	QA Closed:	Date	:	
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			_			Rework	7		Skid-tube Crosstu	ube		Water Jet	Engineering	
Part I	No.			1		Scrap	1		Machining Small F	Fab	Pro	d. Eng. Coor.	Quality	
				Ī		Use-as-is	1	Therm	noforming Finish	ing	Rec/Stor	e/Packaging	Other	
NCR I	No.			[		Work Order Update	] [		Large Fab Compos	site 🔲		Supplier		
Root				Des	•	ption of work order update	1	itial	Action		Sign &			
Cause	Date	Step	Qty		C	or Non-conformance	Chi	ef Eng	Description		Date	Verification	QC Inspector	
Doc/Data				1 1						1				
Equip/Tooling							}					١.		
Operator										1				
Material				1			ļ							
Setup	Ш									-				
Other										1				
Process														
Supplier														
Training														
Unapproved			<u> </u>											
							AULT	CATE	GORY					
Landi	ng Gear			1.		General						_	_	
	Bendin	g		[ ]		Bend	Щ	Grain			Ovalized	_	Pressure/Forced	
	Centre	Not Conce	ntric to	O/S		BOM/Route		Hardwa	re		Over/Under	<del> </del>	Temperature/Cure	
	Cracks					Broken/Damaged		nspecti	ion Incomplete		Part Incorrect		Weld	
İ	Crushe	1/Crimped		1 1		Rurrs	Į ļ	nstruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio DQA: Date:

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance	\approved	QA/NCRWO	Rev C
,	,		

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Ord March-12-13 1				*982	77*							Page 2
Item ID: Revision ID:	D4003-1			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop		S1* S2*
Item Name: Start Date: Required Date	3/11/13	Gutter Line  Start Qty: 4.00  Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				·	T I VI	5/"
Reference: Approvals:	Process	Plan:	Date:	Tooling:	D	ate:	_		Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Re Qt	-	Reject Number	Insp. Stamp
*1		Мето		0.00					13	15	130	
Quality Control											W 13	5.30

NCR:	Yes	/ No
INCIA.	100 /	INU

# WORK ORDER NON-CONFORMANCE / UPDATE

DQA:Date:	DQA:		
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												QA Closed:	Date	•
Work Orde	er:						DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part N	۰ . No						Rework Scrap Use-as-is Work Order Update			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	<b>—</b>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					De	scrip	otion of work order update		nitial	Δ	Action	Sign &		
Cause		Date	Step	Qty		o	or Non-conformance	Ch	ief Eng	Des	scription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			-											
олерриот с	L1		<u> </u>	<u> </u>	\ <del> </del>		F	AUL	T CATE	GORY		<u> </u>	<u> </u>	
Landi		Bending Centre No Cracks Crushed/Cuffs Heat Trea Inspection Ripples in Torque W Turning Si	Crimped et n Strip in Bend Vaves in E	Tube Extrusio			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of 0	ion Incomplete ions Incomplete enance eled	e/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Wave/Tw					Folio	$\vdash$	1	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

March-12-13 1:45:29 PM

Work Order ID:

98277

Parent Item:

D4003-13

Parent Item Name:

Fwd Fuel Gutter Line

**Start Date: 3/11/13** 

Required Date: 3/22/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev A 10.01.12 new issue prelim EC verified by:DD

IPP Rev:B 10.06.22 per dwg rev:A

DD verf:EC

	DD THILL													
Component Item ID/ `Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
<b>M6061T6T0.375W.035</b> 6061-T6 RD Tube .375 x.0	)35W	Purchased	No			100	f	234.0722	0.125	0.5	Е	F 13	!-05-	2
				Location		Loc Qty	Lo	c Code						٠.

 Location
 Loc Qty

 MAT014
 234.0722

 112652
 126.0722

 124491
 108

0.5

NCR:	Yes /	' No
11011.	103/	110

### WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	
	-	

	,								•	QA Closed:	Date	:
Work Orde	r·				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIR Olde			·····		Rework [	$\neg$		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap	_	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	$\dashv$	1	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo				Work Order Update			Large Fab	Composite		Supplier	
			1			<del></del>	<u> </u>			l s: 0		
Root				De	scription of work order update		Initial		ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	- Cr	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data	_											
Equip/Tooling	_										`	
Operator												
Material	_									}	<u>.</u>	
Setup												
Other												
Process												
Supplier												
Training	_											
Unapproved												
						FAUI	LT CATE	GORY				
Landin	ng Gear				General	_	_			-	_	_
1	Bending				Bend	L	Grain			Ovalized	L	Pressure/Forced
	Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	L	Instruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			1	Contamination		Mainte	enance		Part Moved		
	Heat Trea	it		}	Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspection	n Strip in	Tube	1	Cut Too Short		Misread	<b>1</b> _		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		Offset	•				
. [	Torque W	aves in E	xtrusio	n	Drawing		Out of (	Calibration				
	Turning S	equence			Finish		Out of S	Sequence				
ľ	Wave/Tw			1	Folio		Outside	Dimensions				

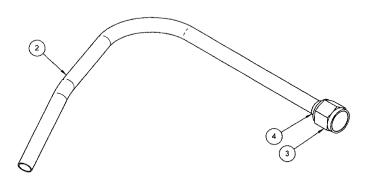
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

TEM NO.	QTY. -047	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION				
			DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER				
1	X	D4003-047	FUEL PUMP INLET PIPE	JCA-M47-2-16				
2	1	D4003-7						
3	. 2	D4003-7 AN818-6D	FUEL INLET PIPE NUT					
4	2	MS20819-6D	SLEEVE					
		WI020019-0D	SLEEVE					
							41. 4	
			(3)				HCT :	
			(4) \				Kr. v.	
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						$\sim$		
						(4)	II .	
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							PAC I	EACEFA
				D4003-047 FUEL PUM	D INI ET DIDE		Mer	EASED 1-05-05
				D-1000-047   OLL FOW	I IIILLI FIFL		<b>H L</b> 2010	)-05-05 <b>5</b> ₩
								MP

Α	NEW IS	SUE		<b>\$</b>	10.02.05		
REV.	DESCRIPTION			BY	DATE		
DESIGN /		45	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED		B	DRAWING NO.		REV. A		
MFG. APPR.		匿	D4003		SHEET 1 OF 9		
APPROVED		10			SCALE		
DE APPR.		#	LINE		NTS		
DATE 10.02.05			COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PREVIOUS AND CONTROL DUTING A THE DIFFLES CONDITION THAT IT IS  NOT TO BE LISED FOR ANY PURPOSE OR CORPOR OF COMMUNICATIO TO ANY OTHER PERSON WITHOUT				

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-047" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.07 lbs

ITEM NO.	QTY. -049	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
. 1	X	D4003-049	TANK VENT LINE ASSEMBLY	JCA-M47-2-17
2	1	D4003-9	VENT LINE	
3	1	AN818-8D	NUT	
4	1	MS20819-8D	SLEEVE	



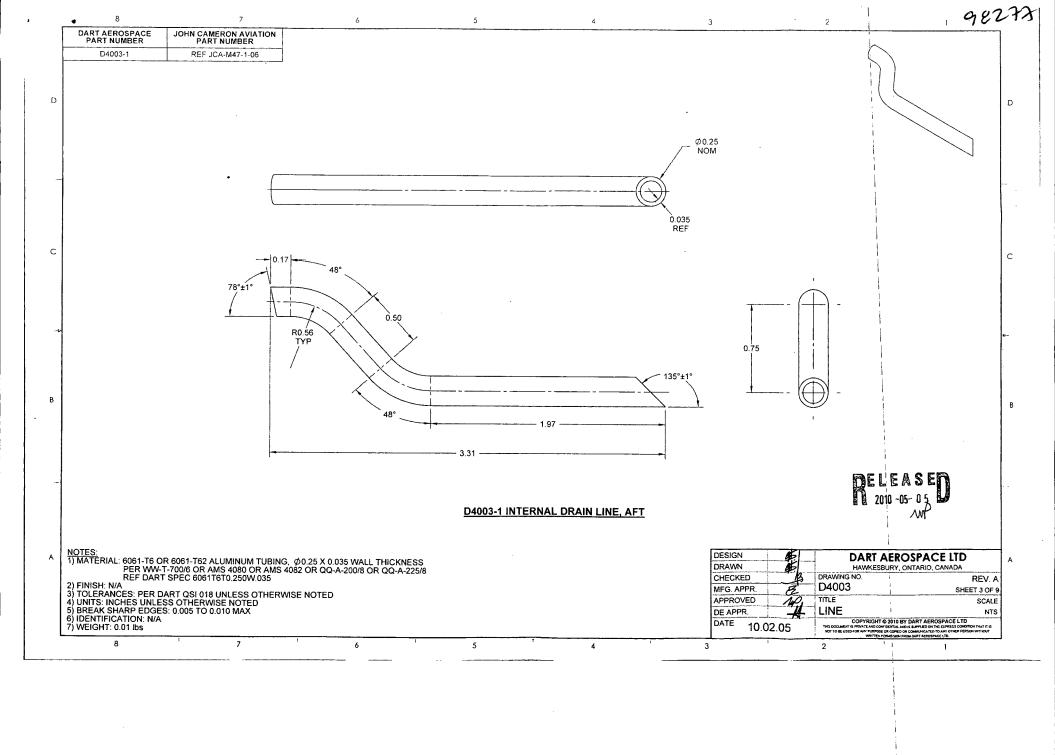
#### **D4003-049 TANK VENT LINE ASSEMBLY**

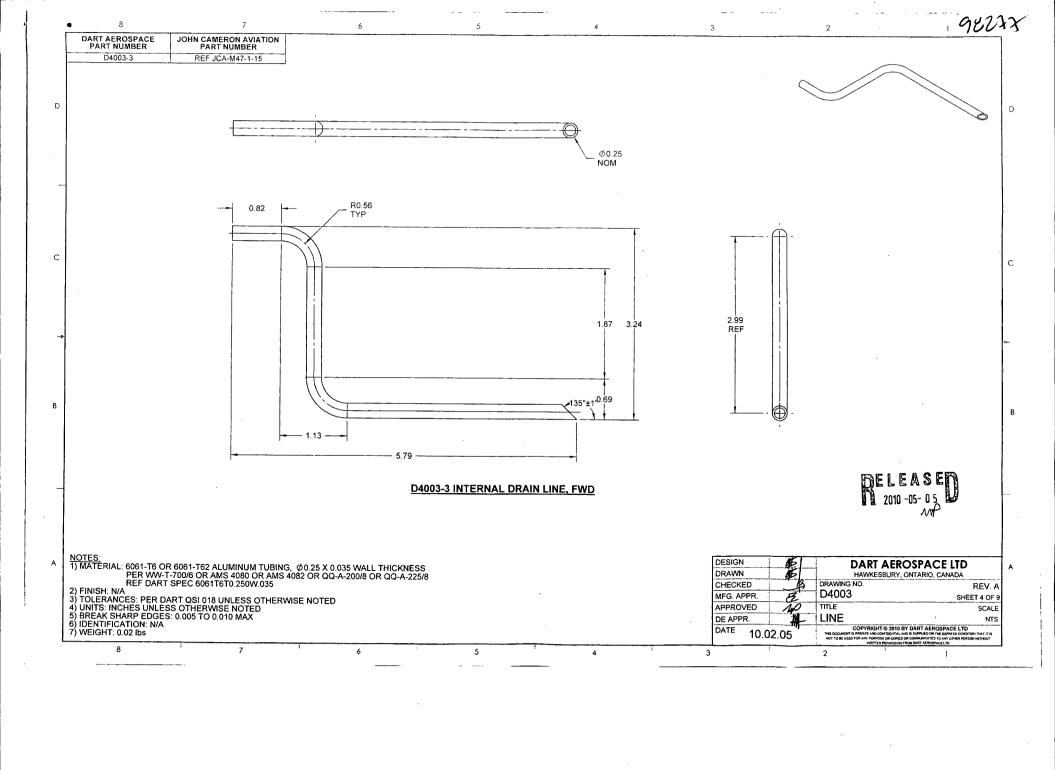
98277

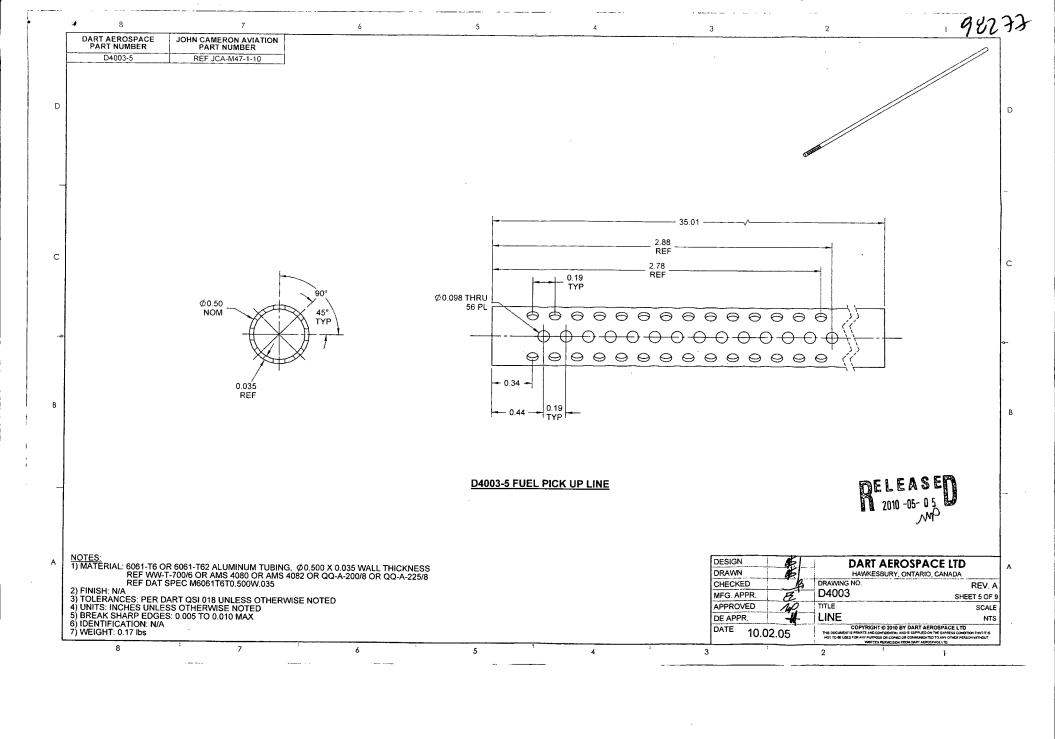
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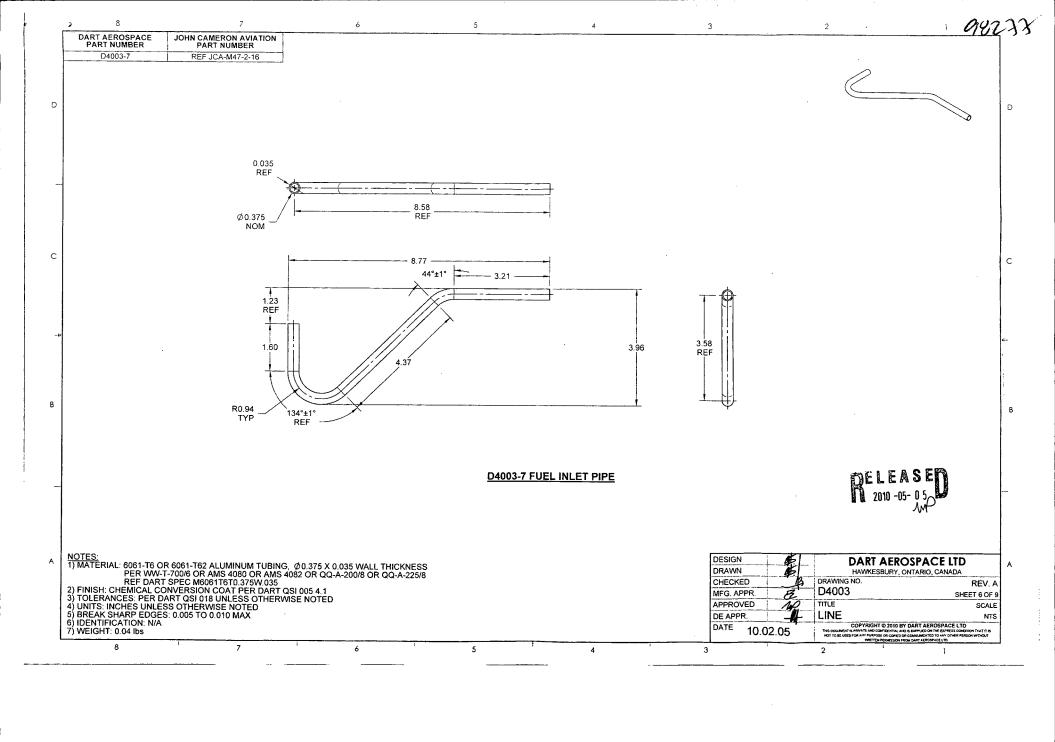
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-049" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.11 lbs

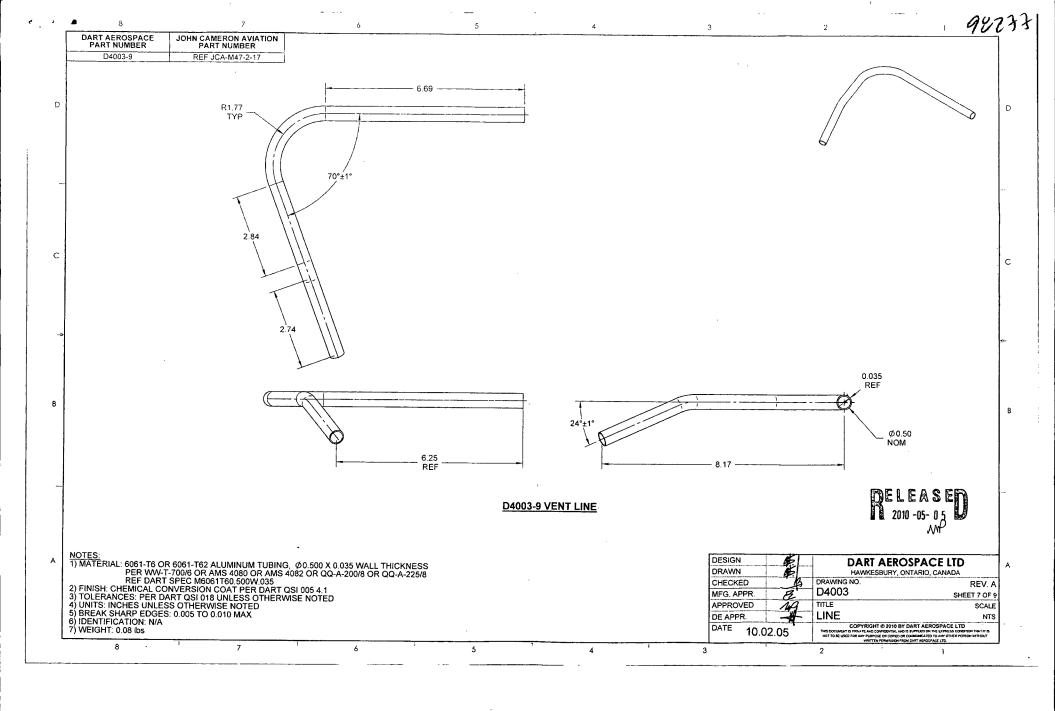
DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. D4003 CHECKED REV. A MFG. APPR. SHEET 2 OF 9 APPROVED TITLE SCALE DE APPR. LINE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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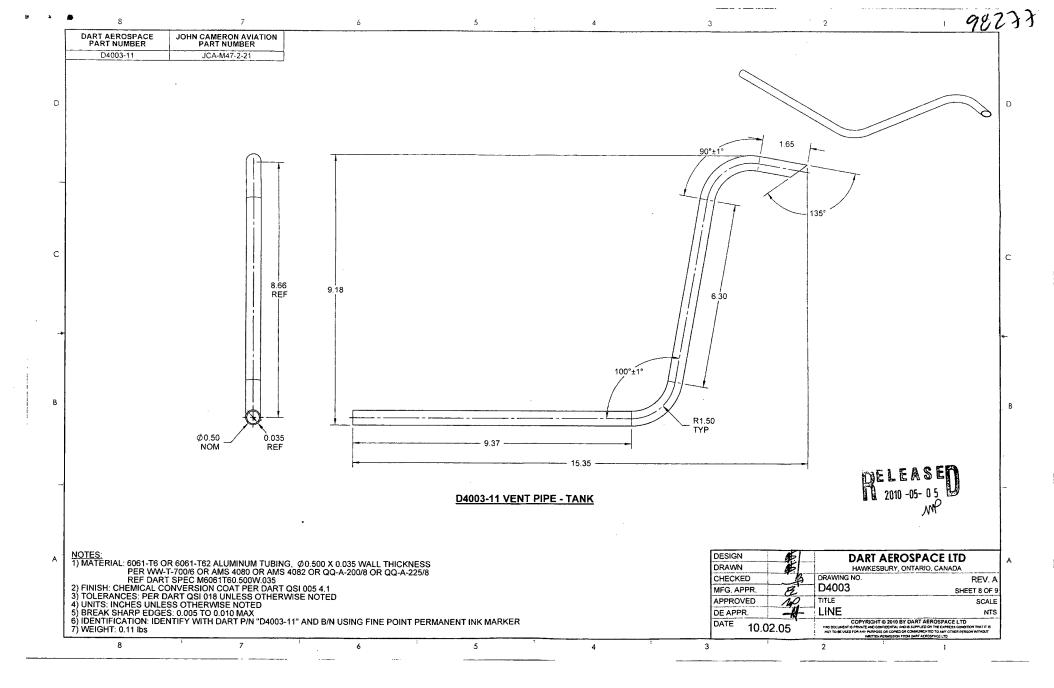








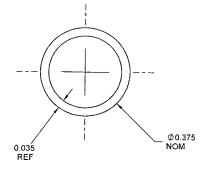


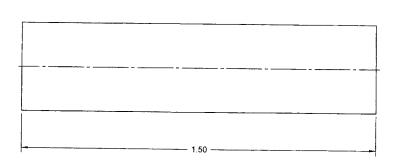


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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4003-13 REF JCA-M47-2-22

8





#### **D4003-13 FORWARD FUEL GUTTER LINE**

NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.375 X 0.035 WALL THICKNESS PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF DART SPEC M6061T6T0.375W.035

REF DART SPEC M6061T6T0.375W.035
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs

DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4003 MFG. APPR. SHEET 9 OF 9 APPROVED TITLE SCALE LINE DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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MOTTOR TRANSCORPING MATTER ARRESON FORCE USER ARRESPORTED. TO DATE 10.02.05

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